

Date: Monday, 18/08/2008 3:45:44 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: UPPER RESTRAINT WELDMENT		
Job Number	: 41377			Part Number	: PB674300131	
Estimate Number	: 13398			Drawing Number	: B6743001 P.41/ P.43	
P.O. Number	:			Project Number	: N/A	
This Issue	: 18/08/2008		S.O. No. :	Drawing Revision	: B1	
Prsh Rev.	: NC			Material	:	
First Issue	: / /		Type :	SMALL /MED FAB	Due Date	: 18/09/2008 Qty: 8 Um: Each
Previous Run	: 40064					
Written By	:					
Checked & Approved By	: <u>JL 08-8-18</u>					
Comment	: Est Rev:A 08-06-20 new issue DD verified by:ec					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S090	6061-T6 .090 Sheet
	Comment: Qty.: 0.4557 sf(s)/Unit Total : 3.6456 sf(s) 6061-T6 .090 Sheet batch: <u>108595</u> <u>B 8-8-21</u>	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg B67-43001-321 Dwg Rev: <u>B1</u> <u>B 8-8-21</u> Prog Rev: <u>B1</u> ***grain direction along 25.00" *** 2-Deburr if necessary <u>B 8-8-21</u>	(10)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 8-8-21</u>	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK <u>808/08/02</u> <u>RE</u>	
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Bend as per Dwg B67-43001 <u>SB 28/09/09</u> <u>10</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/10 000

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(10x)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-f 08/09/10

8.0 POWDER COATING

POWDER COATING



M102316

(10x)

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 8:50

01

OVEN TEMPERATURE: 320

01

FINISH TIME: 9:20

01

m-f 08/09/13

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



P-8/8/10 (10)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PB674300133

Upper Pad Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Upper Pad Assembly

batch: 22878

B41505

Cp 08/10/09

11.0 NAS1149F0316P

WASHER



Comment: Qty.: 5.0000 Each(s)/Unit Total : 40.0000 Each(s)

WASHER

batch: M10 8473

50 R

12.0 MS27039109

Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

batch: 107378

50

R 8/8/10 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg B67-43001.

8/08/10/08 (10)

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/08/10/08 (10)

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST510*

8/08/10/08 (10)

16.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/10 JJ

Job Completion



MF 08-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

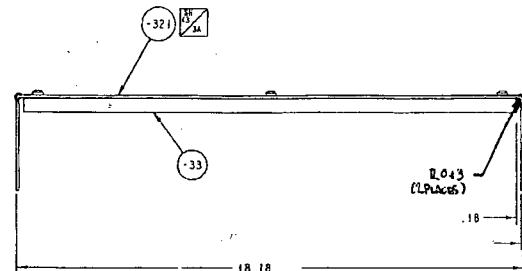
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
01-01-20

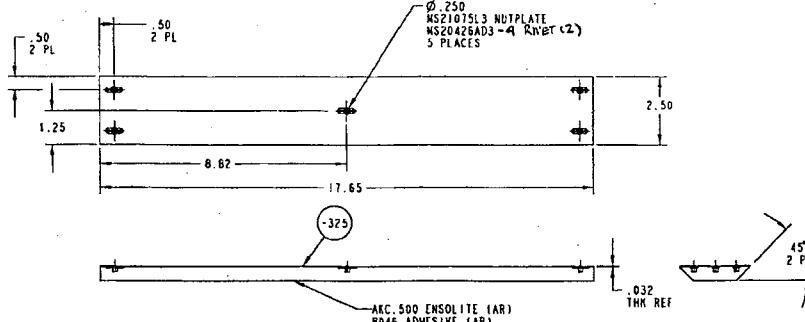


Ø .193 THRU
HATCH DRILL WITH
EXISTING NUTPLATE
LOC'S OF .33
MS27039-1-09 SCREW
NAS1149/0316P WASHLR
5 PLACES



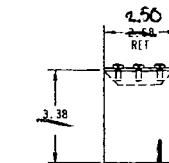
① -31 UPPER RESTRAINT WELDMENT

SCALE 0.500

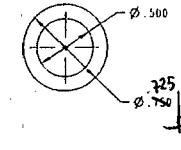


① -33 UPPER PAD ASSY

SCALE 0.500
MATERIAL: .325-.032 THK 2024-T3 AL.
00-A-250/4

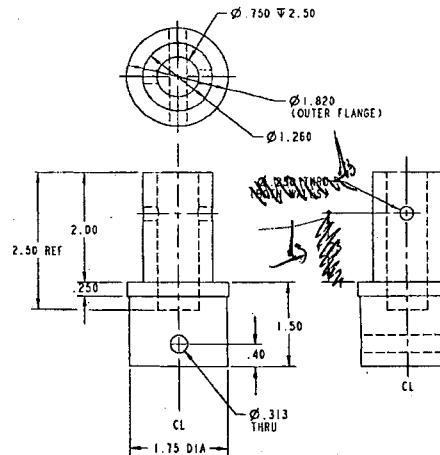


3.600 0809.00



① -299 BUSHING

SCALE 2.000
MATERIAL: 304 CRSS, COND A



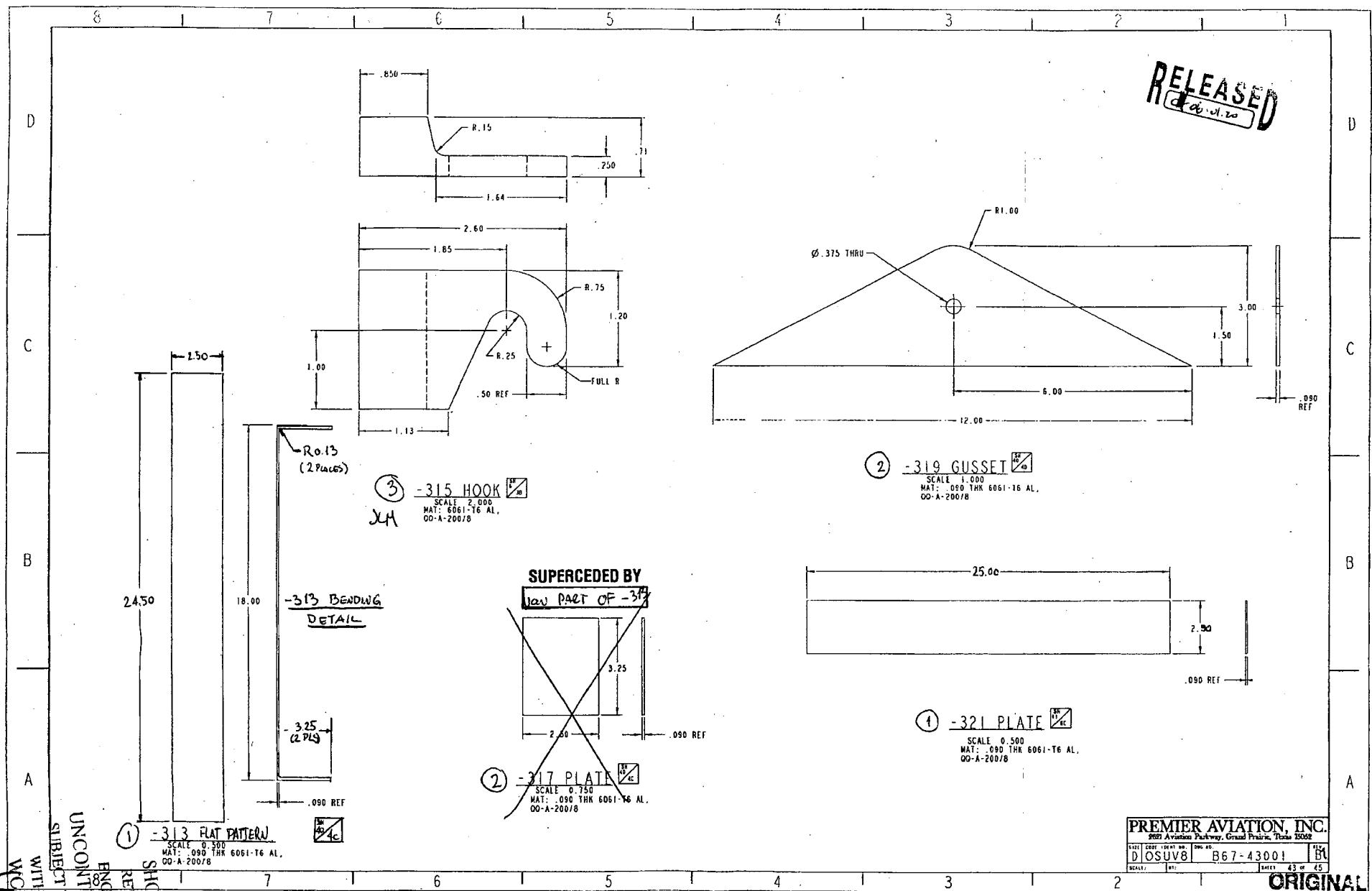
① -305 BEARING

JLM
SCALE 1.000
MATERIAL: 2024-T3 AL.
00-A-200/3

PREMIER AVIATION, INC.
200 Aviation Parkway, Grand Prairie, Texas 75050
SHEET CODE IDENT NO. DRAW NO.
D105UV8 B67-43001
DATE: 4/14/05 BY:

ORIGINAL

NO. 411327
UNCONTROLLED COPY
SHEET TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY



NO. 5132

WORK ORDER

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

ENGINEERING &
RETURN TO

SHOP COPY

PREMIER AVIATION, INC.
9821 Aviation Parkway, Grand Prairie, Texas 75090
DATE: 10/07/01 DRAWN BY: D. OSUVA
SCALE: 1:1

ORIGINAL

DART AEROSPACE LTD	Work Order:	4137
Description: UPPER RESTRAINT WELDMENT	Part Number:	PB6743001-32
Inspection Dwg 20 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: FB	Audited by: C	Prototype Approval: C
Date: 8-8-21	Date: 08/08/21	Date: 7

Rev	Date	Change	Revised by	Approved
A		New Issue	8/10/2017-43001-31	KJ/JLM

H:\FORMS\Quality Assurance\approved QA\FAI revD